



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5149-7TRN
Job Sheet 179773



Part No: D5149-7TRN

Job Qty: 10 ea *14* **DAS**

Part Name: Aft Step Base Turning Detail



8.5A

21
9-89

Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/6/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D SHEET 10 IPP REV:A NEW ISSUE 14-12-08 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		7/6/18	0.00	0.00	Start Up Machining-3		<i>[Signature]</i> DAS 21 9-89 AUG 27 2018
100	Doosan	10 pcs		7/6/18	0.00	10.42	Doosan		
110	QC	10 pcs		7/6/18	0.00	0.00	QC2 Machining-3		
120	QC	10 pcs		7/6/18	0.00	0.00	QC8 Machining-3		
130	Packaging	10 pcs		7/6/18	0.00	0.00	Packaging3-2		
140	QC21-SA	10 Ea		7/6/18	0.00	0.00	QC21		

Part Op 100 - Turn blank as per Folio FB356
Descriptions: 130 - LOCATION: MAT060

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R3.250	6061-T6 Round Bar 3.250"	4.1600 ft (.416 ea)	90-Start up Operation	<i>509812</i> <i>430' per piece</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R3.250	4	19	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Aft Step Base	3.232Inches	+ 0.012 - 0.001	3.244 3.231	
2	Aft Step Base	2.875Inches	+ 0.012 - 0.001	2.887 2.874	<i>2.8805</i>
3	Aft Step Base	0.032Inches	± 0.010	0.042 0.022	Radius
4	Aft Step Base	0.060Inches	± 0.010	0.070 0.050	
5	Aft Step Base	0.060Inches	± 0.030	0.090 0.030	
6	Aft Step Base	0.875Inches	± 0.010	0.885 0.865	
7	Aft Step Base	3.190Inches	± 0.030	3.220 3.160	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : _____							

DQA: _____ Date: _____



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